W	ork	Orde	r ID	60838
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Monday, July 26, 2010 9:48:21 AM



Page 1

Item ID:

D3825-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Rib Assembly (Basket End)

Start Date:

7/26/2010

Start Qty: 6.00

Required Date: 7/30/2010 **Req'd Qty:** 6.00



Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan
Appi uvais.	I i ocess r iaii

QC:

Date: 10-7-26 Tooling:

Date:

Date:

Run Start

Stop

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours**

SPC (Y/N):

Tool ID

Tool # Plan Code

Reject Accept Qty **Qty**

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3825

Rev A

100

Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

1- cut D3825-1 rib as per dwg D3825

Date:

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

- 3- c'sink hole as per dwg
- 4- remove identification markings
- 5- deburr

26-40-01

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825 A/R S.S. Rod Batch: 109213

- 7- grind bushing weld flush where indicated on dwg D3825
- 8- deburr if necessary.

Dart Aerospace Ltd W/O: WORK ORDER CHANGES TATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr OC Inspector Approval QC Inspector

Part No:	_ PAR #: Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verilication	Approval	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	
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Work Order ID 60838 Monday, July 26, 2010 9:48:21 AM Page 2 Item ID: D3825-041 Accept Setup Start **Revision ID:** Item Name: Rib Assembly (Basket End) Stop **Start Date:** 7/26/2010 Start Qty: 6.00 **Cust Item ID:** Required Date: 7/30/2010 Req'd Qty: 6.00 Customer: Reference: Process Plan: _____ Date: ____ Tooling: Approvals: Run Start Date: _____ Date:____ Stop SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Work Center ID Tool # Plan Accept Reject Description Reject Insp. **Run Hours** Code Qty Qty Number Stamp 130 QC9- Inspect visual per QSI004- Fusion Welds 0.00 QC 10.01,29 Memo 0.00 Quality Control 140 QC5- Inspect part completeness to step on W/O 0.00 20129 Memo Quality Control Identify as per dwg & Stock Location: 0.00

150 Packaging

Packaging

0.00

Memo

10-07-09

Dart Aerospace Ltd

W/O:				,								
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Qty Approval Chief Eng / Prod Mgr Approval QC Inspector				
		13.70						Prod Mgr				
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Part No:		PAR #:	Fault Cat	egory:	_ NCR: Yes	No D (A:	Date: _				
	R	esolution:	Disposition	on:	_ QA: N/C Cld	osed: _		Date: _				
NCR:		1	WORK ORE	DER NON-CONFORMA	NCE (NCR)						
	OTED	Description of NC						Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ication tion C	Chief Eng	QC Inspector			
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Work Order ID 60838

Monday, July 26, 2010 9:48:21 AM



Page 3

Item ID:

D3825-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 7/30/2010

Rib Assembly (Basket End)

Start Date:

7/26/2010

Start Qty: 6.00

Req'd Oty: 6.00



Date: _____

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

QC:

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run Start

Qty

Accept

Qty

Stop

Sequence ID/ Work Center ID

160

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

0.00

Reject

Reject Number

Insp. Stamp

Quality Control

Memo

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Other Chief Eng / Prod Mgr Ochief Eng / Prod Mgr Och

Part No:	PAR #:	Fault Category:	NCR: Yes No DQ	A: Date:
Reso	lution:	Disposition:	QA: N/C Closed:	Date:

WORK ORDER NON-CONFORMANCE (NCR)

NCR:	İ								
		Description of NC	Corrective Action Section B				tication	Approval	Approval
DATE S	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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Picklist Print

Monday, July 26, 2010 9:48:26 AM

Work Order ID: 60838

Parent Item: D3825-041

Parent Item Name:

Rib Assembly (Basket End)



Start Date: 7/26/2010

Required Date: 7/30/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

IPP Rev:A 08-12-01 new issue DD verified by:EC

	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	31.0000	1 	6	Col	10.0	7.28°
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				·	58974		1		-	7	_		
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D3759-1		Manufactured	No		00320	100	20 Each	91.0000	-		- /		
	I	Manufactured	140			100	Each	91.0000	, 	6	//_/	,	
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Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Ca	tegory:	NC	R: Yes	No D (A: Date:		
	R	esolution:	Disposit	Disposition: QA: N/C Closed: _					Date: _	
NCR:			WORK OR	DER NON-CONF		(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Section B ription	Section B ption Sign & Section B Date			Approval Chief Eng	Approval QC Inspector	

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QTY -041 ITEM DESCRIPTION D3825-041 RIB ASSEMBLY (BASKET END) X D2327-3 D3759-1 D3825-1 SPACER BUSHING BUSHING RIB

D3825-041 RIB ASSY (BASKET END)

SHOP COPY RETURNITO ENGINEERING UNCONTROLLED CONV SUBJECT TO AMENDMENT WITHOUT NOTICE

Α	NEW IS	SUE		MB	08.09.23				
REV.			DESCRIPTION	BY	DATE				
DESIG	N	16	DART AE	ROSPACE L	ĪD				
DRAW	N	5		Y, ONTARIO, CANAI					
CHECK	(ED	123	DRAWING NO.	· · · · · · · · · · · · · · · · · · ·	REV. A				
MFG. A	PPR.	M.	D3825		SHEET 1 OF				
APPRO	OVED	1,4	TITLE		SCALE				
DE API	REV. DESIGN DRAWN CHECKED MFG. APPR. APPROVED DE APPR.	-#	RIB ASSY (BAS	SKET END)	NTS				
DATE	08.0	9.23	THIS DOCUMENT IS PRIVATE AND CONFIDENTS NOT TO BE USED FOR ANY PURPOSE OR CON	COPYRIGHT © 2008 BY DART AEROS PACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE ENTRESS CONCIDENT THAT IT IS NOT TO BE USED FOR ANY PLAPAGES OF COMEAN MORE TED TO ANY ORIGIN PERSON WITHOUT WRITTEN PRIVATE MANY CAPE ARREPTION TO ANY ORIGINATION TO					

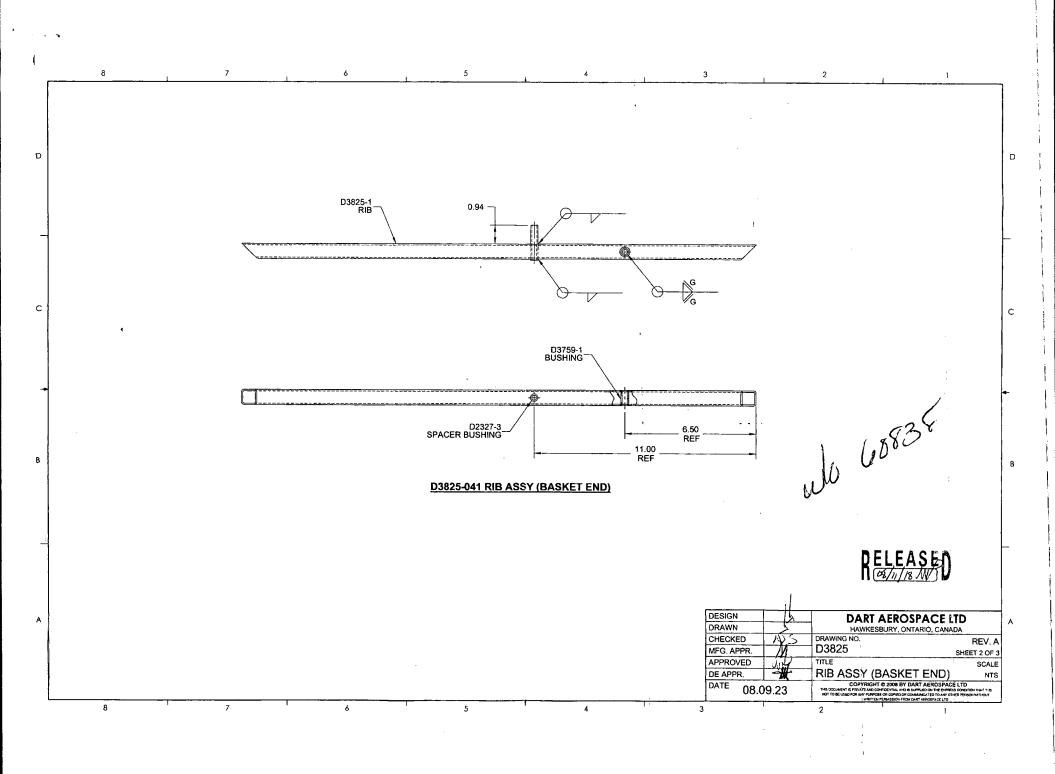
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) WELDING: PER DART QSI 004

2

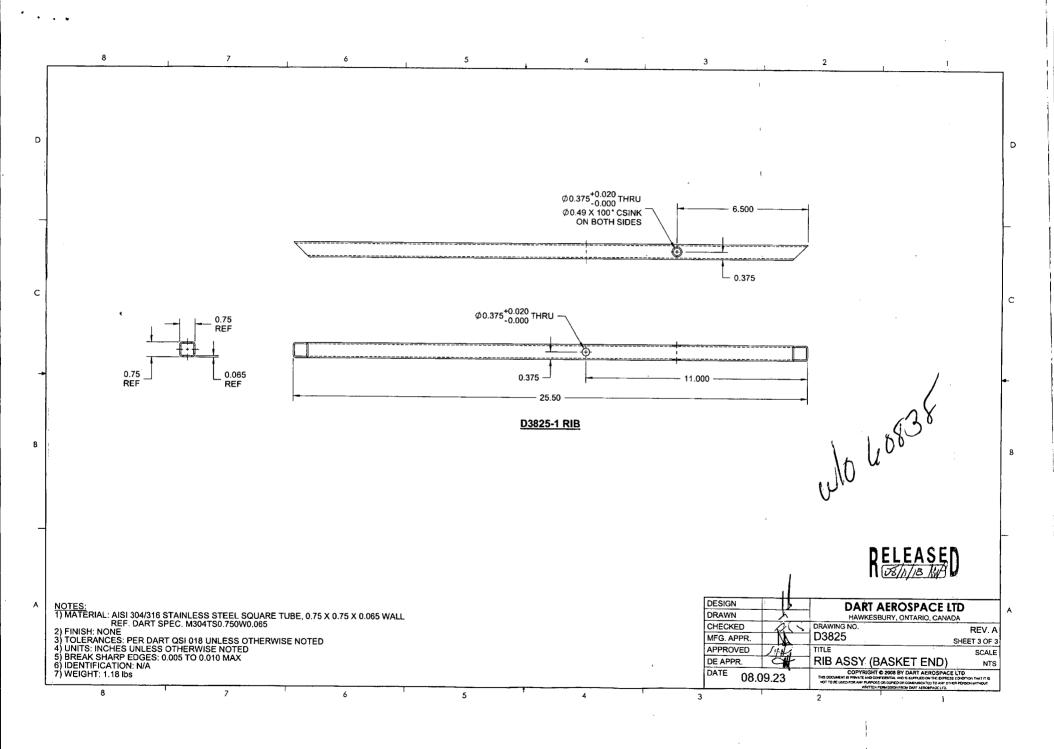
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Dart Aerospace Ltd

W/O:						•			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	tegory:	NCR: Yes	No De	A:	_ Date: _	
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DATE	OTED	Description of NC		on B	Veri	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	k Se	Section C	Chief Eng	QC Inspector
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Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval PROCEDURE CHANGE** Ву DATE **STEP** Qtv Date Chief Eng / QC Inspector Prod Mgr Part No: _____ PAR #: ____ Fault Category: ____ NCR: Yes No DQA: ___ Date: ____ Resolution: _____ QA: N/C Closed: _____ Date: _____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & **Action Description** Initial QC Inspector Section C Chief Eng Section A Date Chief Eng Chief Eng



Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** DATE **STEP PROCEDURE CHANGE** By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DAA: ___ Date: ___ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval** Approval **DATE STEP** Sign & **Action Description** Initial Section C Chief Eng QC Inspector Section A Date Chief Eng Chief Eng